

Work Order ID 92434

92434

Page 1

October-30-12 1:00:22 PM

Item ID: D4410-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Collective Head

Start Date: 10/29/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-16-13

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4410 | B |

| | | | | | | | | | |
|----------------|-------------------------|------|--|--|--|--|--|--|--|
| 100 | Cut blanks as per folio | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Bandsaw | Memo | 0.00 | | | | | | | |
| Jcaspa Bandsaw | CUT BLANK AT 5.00" | | | | | | | | |

B.A 12/11/03

4

φ

DA:
08
9-89

| | | | | | | | | | |
|------------------------------|----------------------------------|------|--|--|--|--|--|--|--|
| 110 | | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| HAAS 1 | Memo | 0.00 | | | | | | | |
| HAAS CNC vertical machine #1 | MACHINE AS PER DWG & FOLIO FB078 | | | | | | | | |
| | FOLIO REV: <u>4A</u> | | | | | | | | |
| | DWG REV: <u>B</u> | | | | | | | | |

ant/B.A 12/11/08

4

φ

DAS
08
9-89

DO NOT BUFF OR POLISH PART****

DEBURR

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|--|------|------|-----|---|-------------------|---|-------------|--------------|--------------|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |

| FAULT CATEGORY | | | | | | | | | | | |
|---|--|--|---|--|--|---|--|--|--|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Work Order ID 92434

October-30-12 1:00:22 PM

92434

Page 2

Item ID: D4410-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Collective Head

Start Date: 10/29/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|---------------------------------------|--------------|---------------|---------------|------------------|--|
| 120 *120* QC Quality Control | QC2- Inspect parts off machine FAI/FAIB Memo | 0.00 0.00 | | <i>OK 12/11/07</i> <i>12/11/08</i> | | <i>4</i> | <i>0</i> | | <i>DAS</i> <i>08</i> <i>9-08</i> |
| 130 *130* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | <i>20 2.11.9</i> | | <i>4</i> | <i>1</i> | | <i>DAS</i> <i>04</i> <i>9-08</i> |
| 140 *140* Packaging Packaging | Identify as per dwg & Stock Location: <i>8T157</i> Memo | 0.00 0.00 | | | | <i>4X</i> | | | <i>SP</i> <i>12-</i> |

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--|------------------------------------|--|--------------------------------------|---|----------------------|---|----------------|--------------|--------------|--|--|------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Skid-tube <input type="checkbox"/></td> <td style="width: 33%;">Crosstube <input type="checkbox"/></td> <td style="width: 33%;">Water Jet <input type="checkbox"/></td> <td style="width: 33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | | | | | | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | | | | | | | | | | | | | | | | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |

| FAULT CATEGORY | | | | |
|---|---|---|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

Work Order ID 92434

92434

Page 3

October-30-12 1:00:22 PM

Item ID: D4410-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Co-Pilot Collective Head

Start Date: 10/29/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/11/13
12-11-09

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|------------------------------------|--|---|---|----------------------|--|----------------|--------------|---|--|--|------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | | | | | | | | | | | | | | | | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | | | | | | | | | | | | | | | | | | |

Picklist Print

October-30-12 1:00:21 PM

Page 1

Work Order ID: 92434

Parent Item: D4410-1

Parent Item Name: Co-Pilot Collective Head

Start Date: 10/29/12

Required Date: 11/16/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11/11/16 JFS VERIFY BY:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B4.500X4.500 | | Purchased | No | | | 100 | f | 4.0260 | 0.42 | 1.7684212 | | 12/11/03 | |
| 6061-T6 Aluminum Bar 4.500" X 4.500" | | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

MAT004

4.026

→ 119581

4.026

1.7684 ft

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

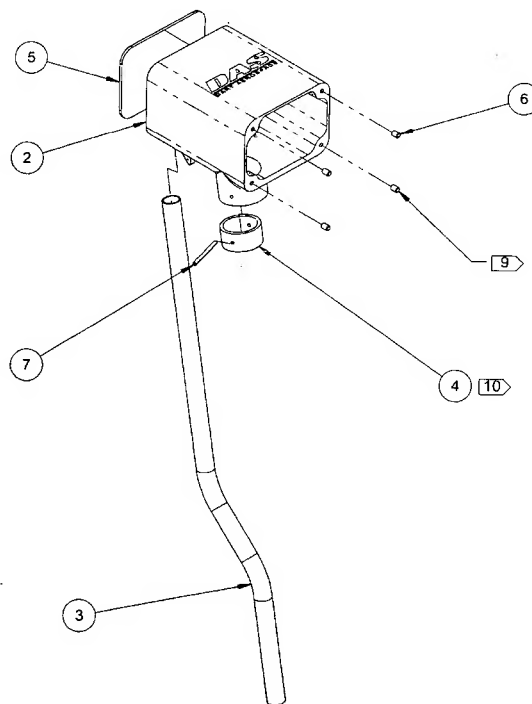
QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--|------------------------------------|--|--------------------------------------|---|--------------------------|--|------------------------|---------------------|---------------------|--|--|------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | | | | | | | | | | | | | | | | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |

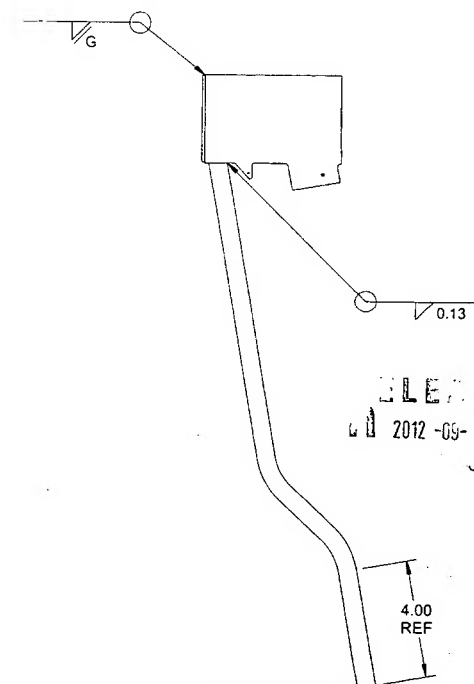
| FAULT CATEGORY | | | |
|---|---|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

| ITEM NO. | QTY. -041 | PART NUMBER | DESCRIPTION |
|----------|--------------|-------------|---|
| 1 | X | D4410-041 | CO-PILOT COLLECTIVE HEAD ASSEMBLY (205) |
| 2 | 1 | D4410-1 | CO-PILOT COLLECTIVE HEAD |
| 3 | 1 | D4410-7 | CONDUIT |
| 4 | 1 | D4410-11 | 205 SHIM |
| 5 | 1 | D4410-15 | REAR COVER |
| 6 | 4 | 90296A108 | HELI-COIL INSERT (6-32 X 0.276) |
| 7 | 1 | MS171539 | PIN |

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WITHOUT NOTICE
WORK ORDER
NO. 92434 MLCJ
12-10-31



D4410-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)



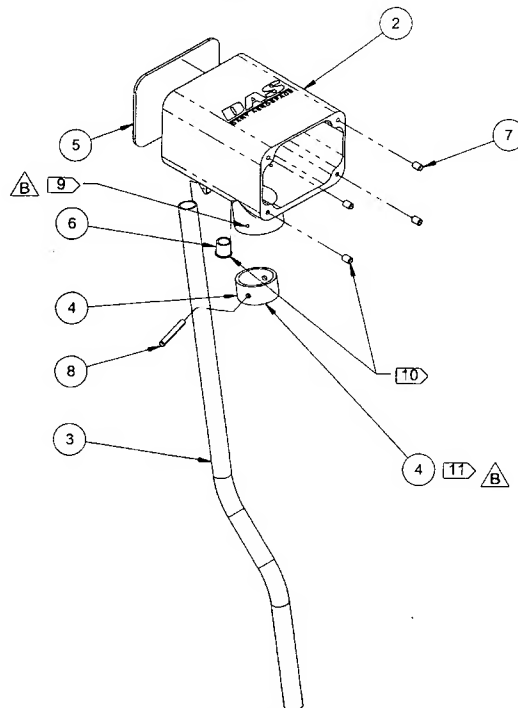
**D4410-041 WELDING DETAIL
(-041 SHOWN, -043/-045 SIMILAR)**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING
- 10) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

| | | | |
|---|--|-------------------------|----------|
| B | ADD C-BORE, ZN A4-2. ENLARGE HOLES, ZN C5-3 & B8-3, UPDATE LOGO, ADD -045/-11/-13/-15. ROTATE HOLE, ZN C3-2 INCREASE 7 DIAMETER, ZN C1-6. REMOVE -9 FROM -041 ASSEMBLY, ZN C5-1. | DC | 12.07.30 |
| A | NEW ISSUE | DC | 11.06.06 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DC | | |
| DRAWN | DC | | |
| CHECKED | DC | | |
| MFG. APPR. | DC | | |
| APPROVED | DC | | |
| DE APPR. | DC | | |
| DATE | 12.07.30 | | |
| DART AEROSPACE USA, INC. KENT, WA | | | |
| DRAWING NO. D4410 | | REV. B SHEET 1 OF 12 | |
| TITLE CO-PILOT COLLECTIVE HEAD | | SCALE NTS | |
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| ITEM NO. | QTY. -043 | PART NUMBER | DESCRIPTION |
|----------|--------------|-------------|---|
| 1 | X | D4410-043 | CO-PILOT COLLECTIVE HEAD ASSEMBLY (212) |
| 2 | 1 | D4410-1 | CO-PILOT COLLECTIVE HEAD |
| 3 | 1 | D4410-7 | CONDUIT |
| 4 | 1 | D4410-13 | 212 SHIM |
| 5 | 1 | D4410-15 | REAR COVER |
| 6 | 1 | D4413-1 | DOME PLUG |
| 7 | 4 | 90296A108 | HELI-COIL INSERT (6-32 X 0.276) |
| 8 | 1 | MS171599 | PIN |



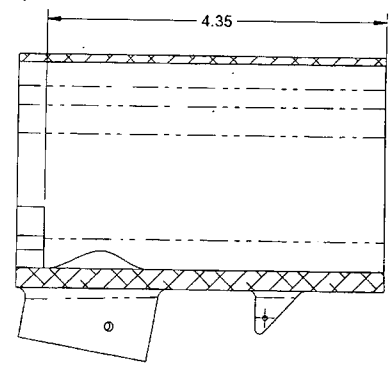
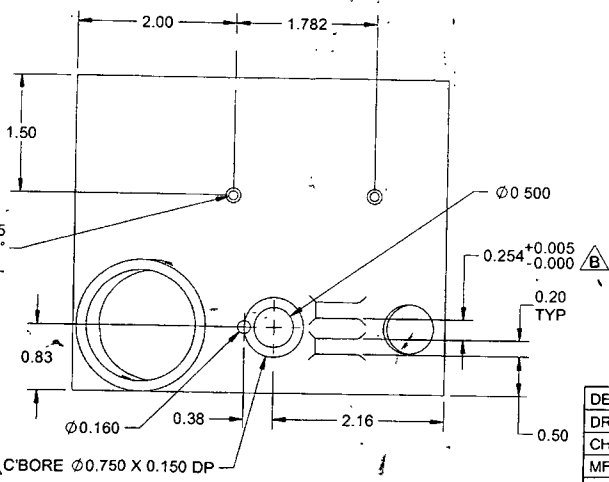
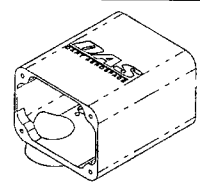
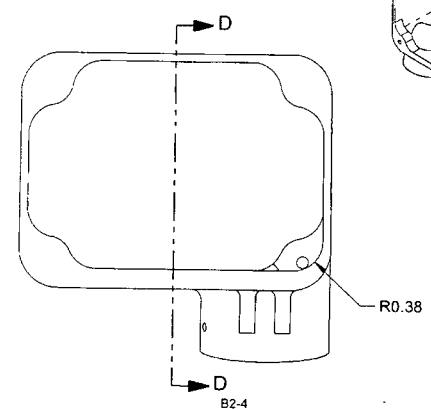
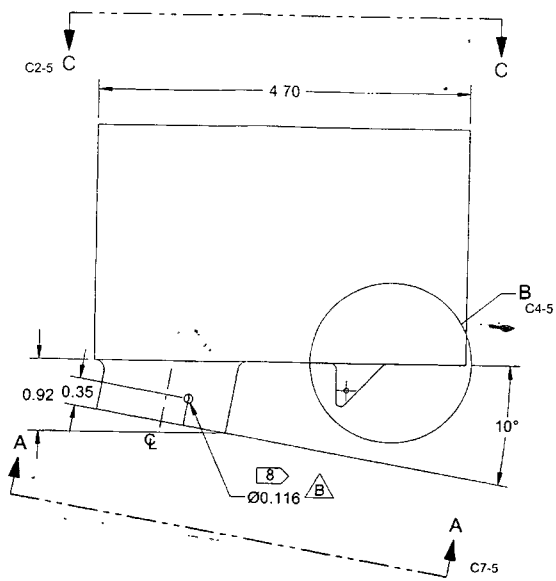
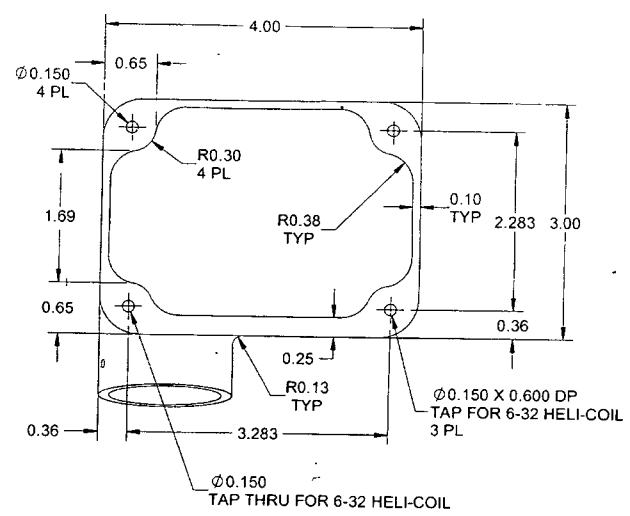
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) REAM TO Ø0.177 (DRILL #16)
- 10) INSTALL AFTER ANODIZING
- 11) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

D4410-043 CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)

| | | | |
|------------|----------|---|---------------|
| DESIGN | DC | DART AEROSPACE USA, INC. | |
| DRAWN | DC | KENT, WA | |
| CHECKED | DC | DRAWING NO. | REV. B |
| MFG. APPR. | DC | D4410 | SHEET 2 OF 12 |
| APPROVED | DC | TITLE | SCALE |
| DE APPR. | DC | CO-PILOT COLLECTIVE HEAD | NTS |
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SECTION D-D
D2-4

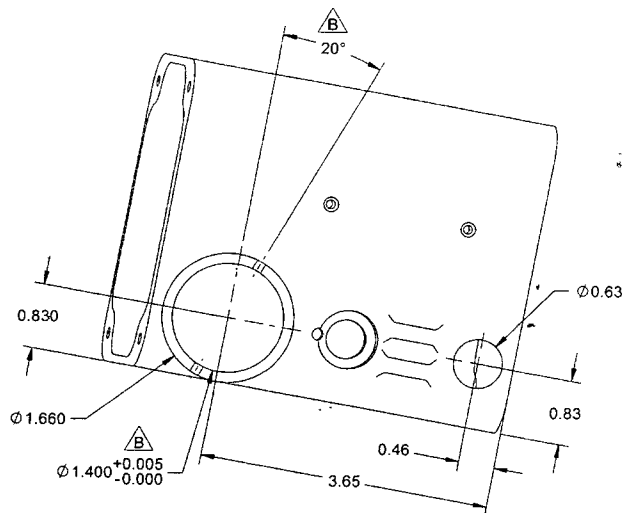
RELEASE
2012-09-28 L
JMP

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B4.000X3.000
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.24 lbs
 - 8) HOLE IS ROTATED 20° COUNTER-CLOCKWISE WHEN VIEWED FROM ABOVE

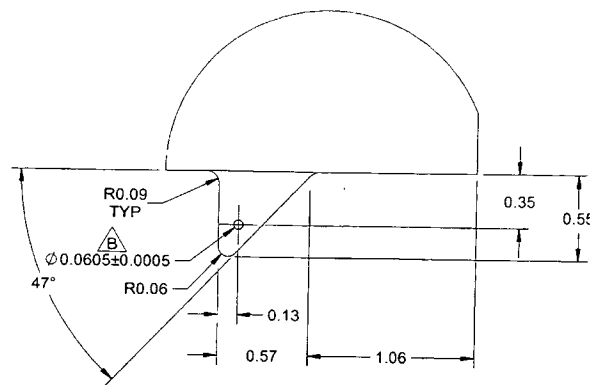
D4410-1 CO-PILOT COLLECTIVE HEAD

| | | | |
|-----------|----------|--|---------------|
| DESIGN | DL | DART AEROSPACE USA, INC. | |
| DRAWN | DL | KENT, WA | |
| CHECKED | DL | DRAWING NO. | REV. B |
| MFG APPR. | DL | D4410 | SHEET 4 OF 12 |
| APPROVED | DL | TITLE | SCALE |
| DE APPR. | DL | CO-PILOT COLLECTIVE HEAD | NTS |
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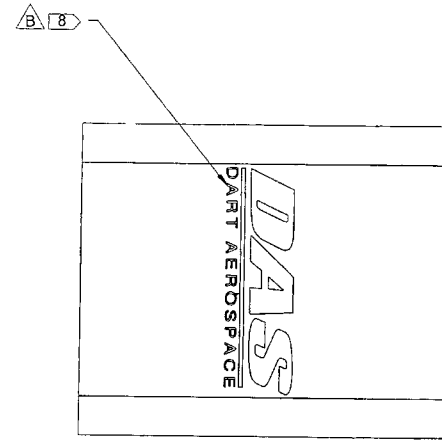
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VIEW A-A
C5-4



DETAIL B
C4-4



VIEW C-C
D4-4

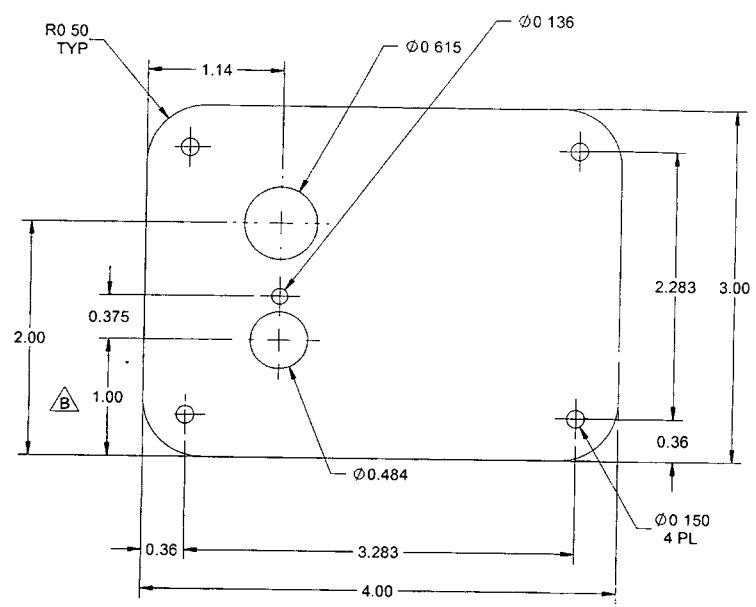
**D4410-1 CO-PILOT COLLECTIVE HEAD
DETAIL VIEWS**

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2012-09-28

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) ENGRAVE "DAS" LOGO AS SHOWN 0.003 - 0.005 DP.

| | | | |
|------------|----------|---|---------------|
| DESIGN | DC | DART AEROSPACE USA, INC. KENT, WA | |
| DRAWN | DC | | |
| CHECKED | ES | DRAWING NO. | REV. B |
| MFG. APPR. | 21 | D4410 | SHEET 5 OF 12 |
| APPROVED | 140 | TITLE | SCALE |
| DE APPR. | 11 | CO-PILOT COLLECTIVE HEAD | NTS |
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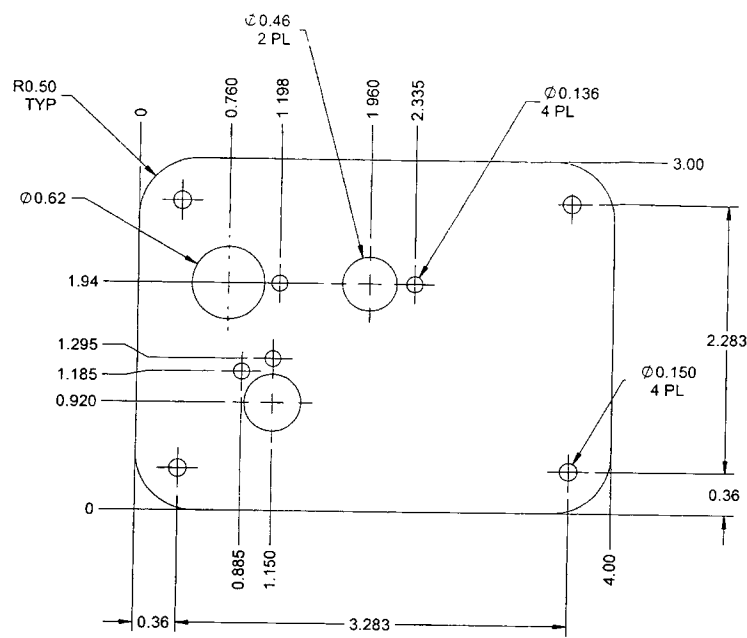
D4410-3 FACE PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
 QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027
 OR ASTM B209
 REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

| | | | |
|------------|----------|---|---------------|
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| DRAWN | DC | KENT, WA | |
| CHECKED | AS | DRAWING NO. | REV. B |
| MFG. APPR. | SL | D4410 | SHEET 6 OF 12 |
| APPROVED | ML | TITLE | SCALE |
| DE APPR. | ML | CO-PILOT COLLECTIVE HEAD | NTS |
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D4410-5 FACE PLATE

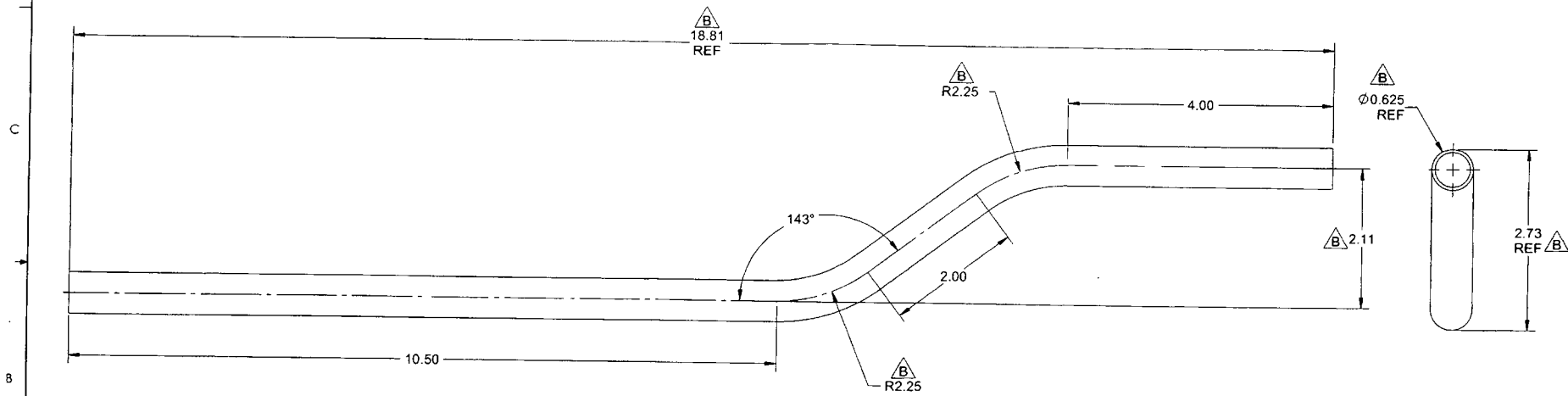
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

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|---|----------|--|---------------|
| DESIGN | DC | DART AEROSPACE USA, INC. | |
| DRAWN | DC | KENT, WA | |
| CHECKED | AB | DRAWING NO. | REV. B |
| MFG. APPR. | SA | D4410 | SHEET 7 OF 12 |
| APPROVED | MD | TITLE | SCALE |
| DE APPR. | SA | CO-PILOT COLLECTIVE HEAD | NTS |
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D4410-7 CONDUIT

RELEASE
2012-09-28

NOTES:

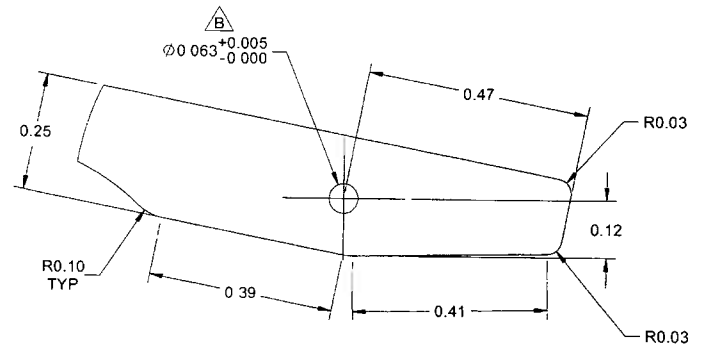
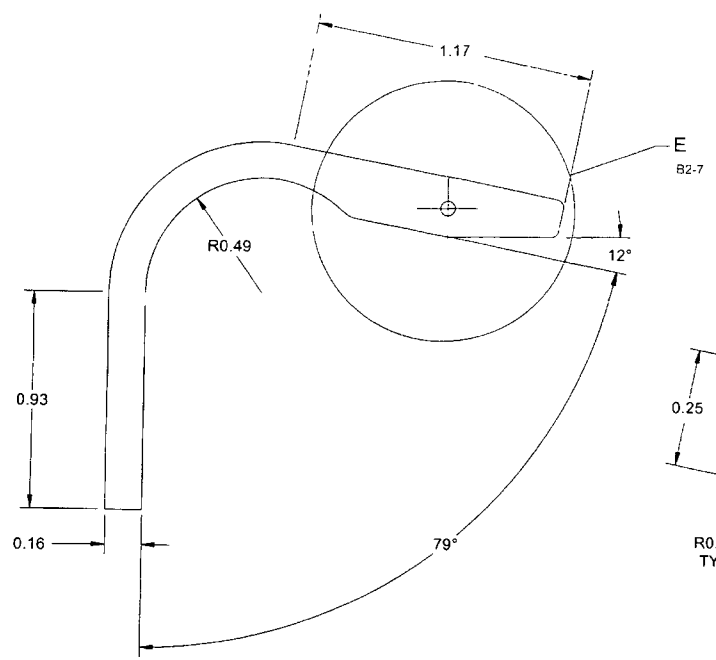
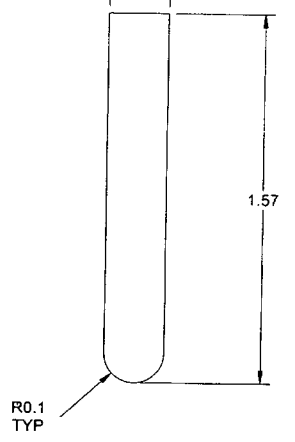
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING PER
WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T60.625W.050
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.17 lbs

| | | | |
|------------|----------|--|---------------|
| DESIGN | DC | DART AEROSPACE USA, INC. | |
| DRAWN | DC | KENT, WA | |
| CHECKED | ES | DRAWING NO. | REV. B |
| MFG. APPR. | 21 | D4410 | SHEET 8 OF 12 |
| APPROVED | 142 | TITLE | SCALE |
| DE APPR. | 44 | CO-PILOT COLLECTIVE HEAD NTS | |
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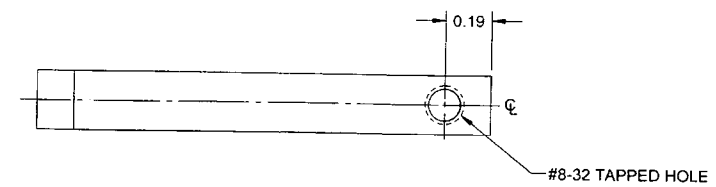
92434

8 7 6 5 4 3 2

$\triangle B$
+0.000
-0.005
REF



DETAIL E
D4-7



D4410-9 TRIGGER

NOTES:

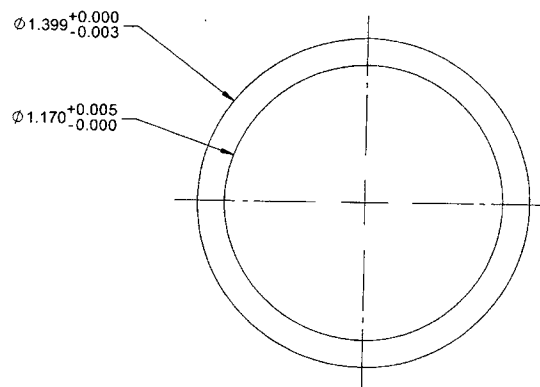
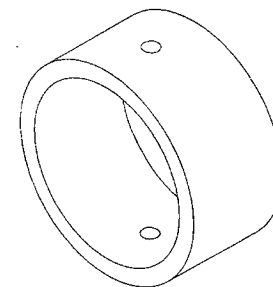
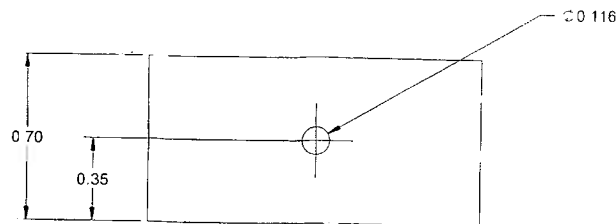
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.250 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.250
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

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2012-09-28

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|------------|----------|---|---------------|
| DESIGN | BC | DART AEROSPACE USA, INC. | |
| DRAWN | BC | KENT, WA | |
| CHECKED | BC | DRAWING NO. | REV. B |
| MFG. APPR. | BC | D4410 | SHEET 9 OF 12 |
| APPROVED | BC | TITLE | SCALE |
| DE APPR. | BC | CO-PILOT COLLECTIVE HEAD | NTS |
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8 7 6 5 4 3 2

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D4410-11 205 SHIM

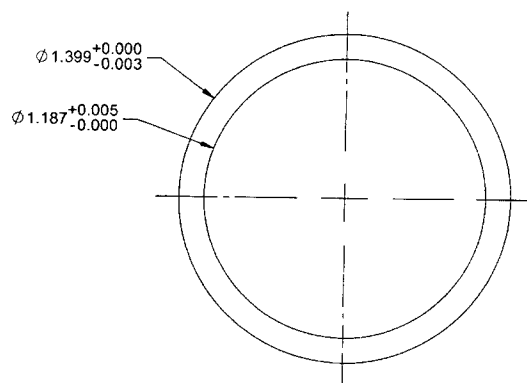
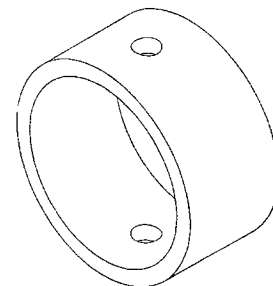
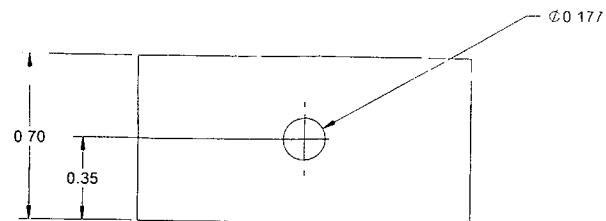
RELEASED
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AMP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6R1.500
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

| | | | |
|------------|----------|--|----------------|
| DESIGN | BC | DART AEROSPACE USA, INC. | |
| DRAWN | BC | KENT, WA | |
| CHECKED | BC | DRAWING NO | REV. B |
| MFG. APPR. | 21 | D4410 | SHEET 10 OF 12 |
| APPROVED | 142 | TITLE | SCALE |
| DE APPR. | 142 | CO-PILOT COLLECTIVE HEAD | NTS |
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D4410-13 212 SHIM

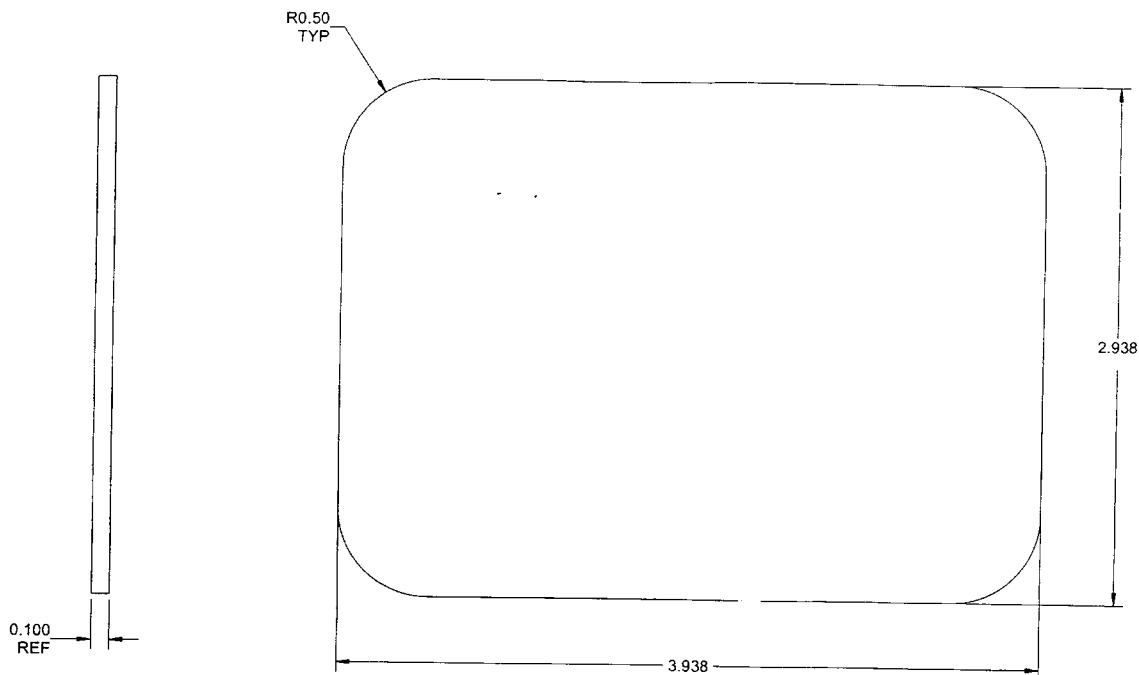
RELEASED
2012-09-28
WMP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6R1.500
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

| | | | |
|------------|----------|---|----------------|
| DESIGN | DC | DART AEROSPACE USA, INC. | |
| DRAWN | DC | KENT, WA | |
| CHECKED | DC | DRAWING NO. | REV. B |
| MFG. APPR. | 21 | D4410 | SHEET 11 OF 12 |
| APPROVED | 14 | TITLE | SCALE |
| DE APPR. | 14 | CO-PILOT COLLECTIVE HEAD | NTS |
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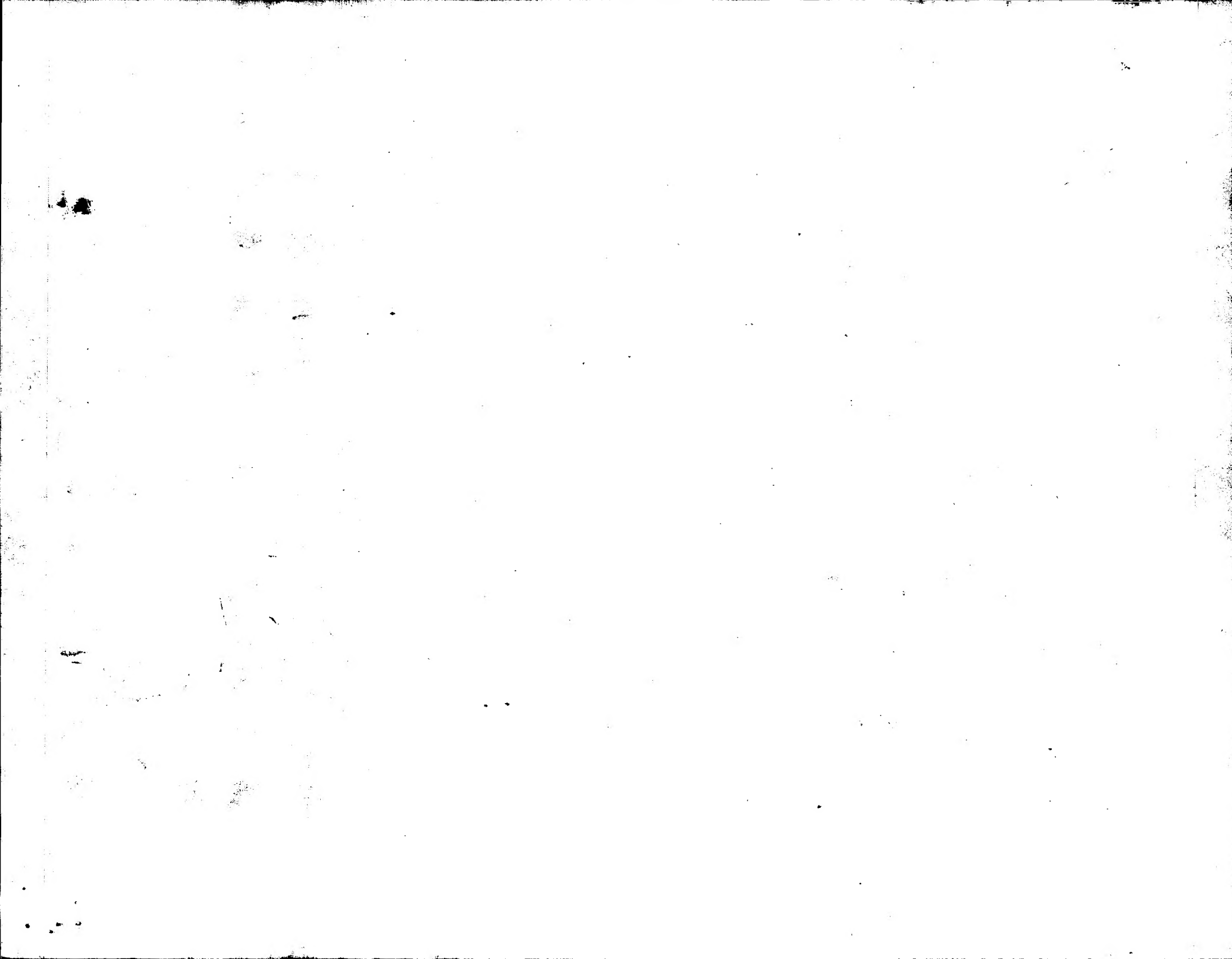


D4410-15 REAR COVER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.100 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.100
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.11 lbs

| | | | |
|------------|----------|---|----------------|
| DESIGN | BC | DART AEROSPACE USA, INC. | |
| DRAWN | BC | KENT, WA | |
| CHECKED | BC | DRAWING NO. | REV. B |
| MFG. APPR. | BC | D4410 | SHEET 12 OF 12 |
| APPROVED | BC | TITLE | SCALE |
| DE APPR. | BC | CO-PILOT COLLECTIVE HEAD | NTS |
| DATE | 12.07.30 | COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |



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|---|-----------------------------|
| DART AEROSPACE LTD | Work Order: 92 434 |
| Description: C.O-PILOT COLLECTIVE HEAD | Part Number: D4410-1 |
| Inspection Dwg: D4410 Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|--------------------------|------------------|--------|--------|----------------------|----------|
| 4.00 | $\pm .030$ | 4.002 | — | | Vern | ML-DL |
| .65 | $\pm .030$ | .650 | — | | " | " |
| $\phi .150$ | $\pm .005$ $\pm .001$ | $\phi .152$ | — | | " | " |
| 1.69 | $\pm .030$ | 1.690 | — | | " | " |
| .65 | $\pm .030$ | .650 | — | | " | " |
| .36 | $\pm .030$ | .360 | — | | " | " |
| 3.283 | $\pm .005$ | 3.282 | — | | " | " |
| R.13 | $\pm .030$ | R.125 | — | | R-G | " |
| .25 | $\pm .030$ | .253 | — | | Vern | ML-06 |
| .600 ∇ | $\pm .010$ | .610 | — | | " | " |
| .36 | $\pm .030$ | .360 | — | | " | " |
| 2.283 | $\pm .085$ | 2.282 | — | | " | " |
| 3.00 | $\pm .030$ | 2.999 | — | | Vern | GA-01 |
| 4.70 | $\pm .030$ | 4.697 | — | | Vern | ML-DL |
| 10° | $\pm 1/2^\circ$ | 10° | — | | C-Aquare | ML-LBB |
| $\phi .116$ | $\pm .004$ $\pm .001$ | $\phi .118$ | ✓ | | Vern | GA-01 |
| .35 | $\pm .030$ | 0.350 | ✓ | | " | " |
| .92 | $\pm .030$ | .917 | — | | Vern | ML-DL |
| 4.35 | $\pm .030$ | 4.355 | — | | " | " |
| 2.00 | $\pm .030$ | 1.999 | — | | " | " |
| 1.782 | $\pm .005$ | 1.783 | — | | " | " |
| 1.50 | $\pm .030$ | 1.5005 | — | | " | " |
| $\phi .115$ | $\pm .004$ $\pm .001$ | $\phi .117$ | — | | " | " |

| | | |
|-------------------------------|--|------------------------------|
| Measured by: <i>mf</i> | Audited by: <i>EL</i> (DAS) 04 2-82 | Preliminary Approval: |
| Date: 12/11/07 | Date: 12.11.9 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| E | 10.04.14 | Added preliminary approval | KJ | |

10.04.15

| | |
|--|-----------------------------|
| DART AEROSPACE LTD | Work Order: 92434 |
| Description: CD-PILDT COLLECTIVE HEAD | Part Number: D4410-1 |
| Inspection Dwg: D4410 Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|----------------|------------------|--------|--------|----------------------|----------|
| Ø.188 X 106° | ±.010 X ± 1/2° | Ø0.194 X 100° | ✓ | | Vern | GA-01 |
| .83 | ±.030 | 0.833 | ✓ | | H-G | 31006 |
| Ø.160 | ±.005 ±.001 | Ø0.161 | ✓ | | Vern | GA-01 |
| Ø.750 | ±.010 | Ø0.750 | ✓ | | " | " |
| .150 ↓ | ±.010 | 0.149 | ✓ | | D-G | GA-08 |
| 2.16 | ±.030 | 2.159 | ✓ | | H-G | 31006 |
| .50 | ±.030 | 0.505 | ✓ | | " | " |
| .20 | ±.030 | 0.201 | ✓ | | Vern | GA-01 |
| .254 | ±.005 ±.001 | 0.254 | ✓ | | " | " |
| Ø.500 | ±.006 ±.001 | Ø0.501 | ✓ | | " | " |
| .830 | ±.005 | 0.833 | ✓ | | H-G | 31006 |
| Ø1.660 | ±.010 | Ø1.5585 | ✓ | | Mic | GA-02 |
| Ø1.400 | ±.005 ±.001 | Ø1.4004 | ✓ | | Mic | GA-02 |
| 3.65 | ±.030 | 3.650 | ✓ | | H-G | 31006 |
| .46 | ±.030 | 0.456 | ✓ | | " | " |
| .83 | ±.030 | 0.833 | ✓ | | " | " |
| Ø.63 | ±.030 | Ø0.629 | ✓ | | Vern | GA-01 |
| 20° | ± 1/2° | 20° | ✓ | | C-square | ML-CBR |
| .35 | ±.030 | 0.345 | ✓ | | H-G | 31006 |
| .55 | ±.030 | 0.550 | ✓ | | " | " |
| 1.06 | ±.030 | 1.055 | ✓ | | Vern | GA-01 |
| .13 | ±.030 | 0.126 | ✓ | | H-G | 31006 |
| .57 | ±.030 | 0.590 | ✓ | | Vern | GA-01 |

| | | |
|--------------------------------|--|------------------------------|
| Measured by: 08 9-89 | Audited by: DP (DAS) 04 9-89 | Preliminary Approval: |
| Date: 12/11/08 | Date: 12.11.9 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| E | 10.04.14 | Added preliminary approval | KJ | |

10.04.15

